

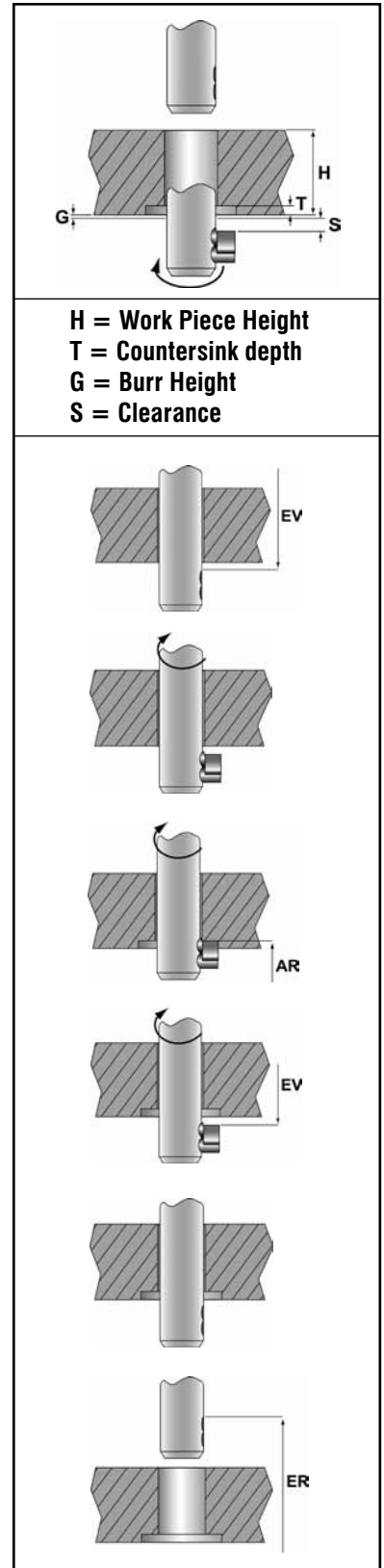
## SOLO 1000 Red/1900 Black Ring Programming Information

**Attention:** Pay attention to the speed rate of your tool head. The blade will move out sooner than the tool rated but cutting should only be made at or above the rated speed.

1. With no spindle rotation, pass through the workpiece (blade is retracted)  
EV = Fwd Feed.
2. Activate spindle in normal clockwise rotation (blade will extend within rated head speed. (RED=1000 RPM / BLACK=1900 RPM)
3. Dwell a minimum 1 second to allow insert to fully extend.
4. Turn coolant on.
5. Back feed and machine your workpiece. AR = Working Feed
6. Travel out of work piece. EV = Forward Feed.
7. Turn coolant off.
8. Spindle Stop, speed rate: 0 (blade will retract).
9. Dwell minimum of 1-2 seconds.
10. With stopped spindle, retract the tool from the workpiece (blade is retracted: speed rate is 0). ER = Rapid Back Feed.

**IMPORTANT:** Do not run dry! Coolant supply to the blade must be adequate.

Material	Speed <small>Surface footage are recommendations only; Remember you must run the minimum of your rate Tool Head (reduce for interrupted cuts).</small>	Feed (IPR) <small>Based on bore Ød : Counterbore ØD ratio Rt=ØD/Ød</small>	
		Rt<1.6	Rt>1.6
Aluminum	600-800	.004-.008	.0020-.0030
Stainless Steel	140-300	.003-.005	.0008-.0015
Titanium	60-180	.001-.003	.0008-.0015
Inconel	40-90	.001-.002	.0007-.0012
Cast Iron	260-400	.004-.007	.0010-.0025
Carbon Steel	210-350	.003-.006	.0010-.0020



## SOLO S2 (Orange/Green Ring) Programming Information

**Attention:** The SOLO S2 works opposite of the SOLO 1000. The cutting blade is always active until the spindle reaches 2000 RPM. Please remain under 750 RPM when cutting.

1. With 2000 RPM spindle rotation, pass through the workpiece (blade is retracted). EV = Forward Feed.
2. Slow spindle maximum ORANGE=750 RPM / GREEN=1500 RPM in normal clockwise rotation (blade will extend).
3. Dwell a minimum of 1 second to allow insert to fully extend.
4. Turn coolant on.
5. Back Feed and machine your workpiece. AR = Working Feed.
6. Travel out of workpiece. EV = Forward Feed.
7. Turn coolant off.
8. Increase spindle speed >2000 RPM, speed ratio: min 2000 RPM (blade will retract).
9. Dwell minimum 1-2 seconds.
10. With spindle rotating at 2000 RPM retract the tool from the work piece (blade is retracted; speed rate is min 2000). ER = Rapid Back Feed.

**IMPORTANT:** Do not run dry! Coolant supply to the blade must be adequate.

Material	Speed <small>Surface footage are recommendations only; Remember you must run the minimum of your rate Tool Head (reduce for interrupted cuts).</small>	Feed (IPR) <small>Based on bore Ød : Counterbore ØD ratio Rt=ØD/Ød</small>	
		Rt<1.6	Rt>1.6
Aluminum	600-800	.004-.008	.0020-.0030
Stainless Steel	140-300	.003-.005	.0008-.0015
Titanium	60-180	.001-.003	.0008-.0015
Inconel	40-90	.001-.002	.0007-.0012
Cast Iron	260-400	.004-.007	.0010-.0025
Carbon Steel	210-350	.003-.006	.0010-.0020

